

Work Order ID 71204

Thursday, June 23, 2011 1:26:13 PM



Page 1

Item ID: D206-558-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Single Cargo Mirror Assembly

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D206-558	Rev C								

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D206-558-041 DSI 9436
CHG009

Sulstar

CL 11-7-13

110

0.00



Small Fab

Small Fab

Small Fab

Memo

0.00

Assemble as per Dwg D206-558
PAGE 10 IN BLUE FILE

8/5/07/13 *(4)*

120

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Sulstar

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71204

Thursday, June 23, 2011 1:26:13 PM

Page 2

Item ID: D206-558-041

Accept:

Setup Start

Revision ID:

Stop

Item Name: Single Cargo Mirror Assembly

Start Date: 6/23/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

125

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/18/13

130

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/16/14

x4

140

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-558-041 DSI 9436

Location: 42
PPP Rev: K

11/17/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71204

Thursday, June 23, 2011 1:26:13 PM

Page 3

Item ID: D206-558-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Single Cargo Mirror Assembly

Start Date: 6/23/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/6/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/14
MF
11-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, June 23, 2011 1:26:10 PM




Page 1

[illegible]

Required Date: 7/6/2011

Required Qty: 4.00

Comments: IPP F02.09.19 Re-format; Incorporated D2065 KJ
IPP Rev:G 08-05-14 now @chg006/ add D3778-1 per ECN1171 DD
verified:ec
IPP Rev:H 08-08-19 now @chg 007 DD verified by:ec IPP Rev:I
10.03.17 add pick kit DD verified by:JLM IPP REV:J 11.01.19 AS
PER CHG009 DD VERE:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 	NAS1149D0363J	Purchased	No			110	Each	0.0000	4	16		EP 11/07/13	
Washer D2011-101 		Manufactured	No			110	Each	3.0000	1	4		EP 11/07/13	
6" Mirror												B 70729 (40)	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST221				3					
				65838				3					
D2052 		Manufactured	No			110	Each	14.0000	2	8		EP 11/07/13	
Mounting Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				14					
				67743				14					
D2053 		Manufactured	No			110	Each	7.0000	1	4		11/7/13	
Mounting Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST005				7					
				65837				7					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC-Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 1:26:10 PM

Page 2

Work Order ID: 71204

Parent Item: D206-558-041

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 4.00

Required Qty: 4.00

D2054
Bushing

Manufactured No

110 Each

44.0000

2

8

Location

Loc Qty

Loc Code

GA

44

67784

44

D2055
Clamp

Manufactured No

110 Each

7.0000

1

4

Location

Loc Qty

Loc Code

GA

7

66184

7

D2056
Bell Crank

Manufactured No

110 Each

0.0000

1

4

D2057
Plug

Manufactured No

110 Each

2.0000

1

4

Location

Loc Qty

Loc Code

ST005

2

60880

2

D2065
Arm

Manufactured No

110 Each

2.0000

1

4

Location

Loc Qty

Loc Code

ST229

2

61381

2

B71102 (42)

B71104 (22)

Thursday, June 23, 2011 1:26:10 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 1:26:10 PM

Work Order ID: 71204

Parent Item: D206-558-041

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

110

Each

2,025.000

2

8



Nut



EP 5/11/07/13

Location

Loc Qty

Loc Code

ST300

2025

116549

325

117441

800

117601

400

117885

500

8

MS27039-1-18

Purchased

No

110

Each

90.0000

2

8



Screw



EP 11/07/13

Location

Loc Qty

Loc Code

ST292

90

115589

90

8

AN3-4A

Purchased

No

125

Each

635.0000

4

16



Bolt



SD

Location

Loc Qty

Loc Code

ST350

635

104291

300

104625

300

114374

35

16

AN526-1032R9

Purchased

No

125

Each

128.0000

4

16



Screw



11/7/13 SD (4)

Location

Loc Qty

Loc Code

ST328

128

116900

28

117395

100

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 1:26:10 PM

Page 4

Work Order ID: 71204

Parent Item: D206-558-041

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD10L NAS1149D0332J Purchased No

125 Each

0.0000

6 24



Washer

D2067

Manufactured No

125 Each

29.0000

1 4



Connector

Location

Loc Qty

Loc Code

ST005

29

67403

29

D2071

Manufactured No

125 Each

15.0000

1 4



Cable Assembly

Location

Loc Qty

Loc Code

ST222

15

69196

15

D3778-1

Manufactured No

125 Each

7.0000

1 4



Bracket

Location

Loc Qty

Loc Code

ST228

7

68695

7

MS21042L3

Purchased No

125 Each

2,025.000

1 4



Nut

Location

Loc Qty

Loc Code

ST300

2025

116549

325

117441

800

117601

400

117885

500

Thursday, June 23, 2011 1:26:10 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

Thursday, June 23, 2011 1:26:10 PM

Work Order ID: 71204

Parent Item: D206-558-041

Parent Item Name: Single Cargo Mirror Assembly

Start Date: 6/23/2011

Required Date: 7/6/2011

Start Qty: 4.00

Required Qty: 4.00

MS21919-DG5

Purchased

No

125

Each

56.0000

2

8



Clamp

Location

Loc Qty

Loc Code

ST306

56

117395

26

118077

30

MS35489-9

Purchased

No

125

Each

49.0000

1

4



Grommet

Location

Loc Qty

Loc Code

ST296

49

107376

49

Thursday, June 23, 2011 1:26:10 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

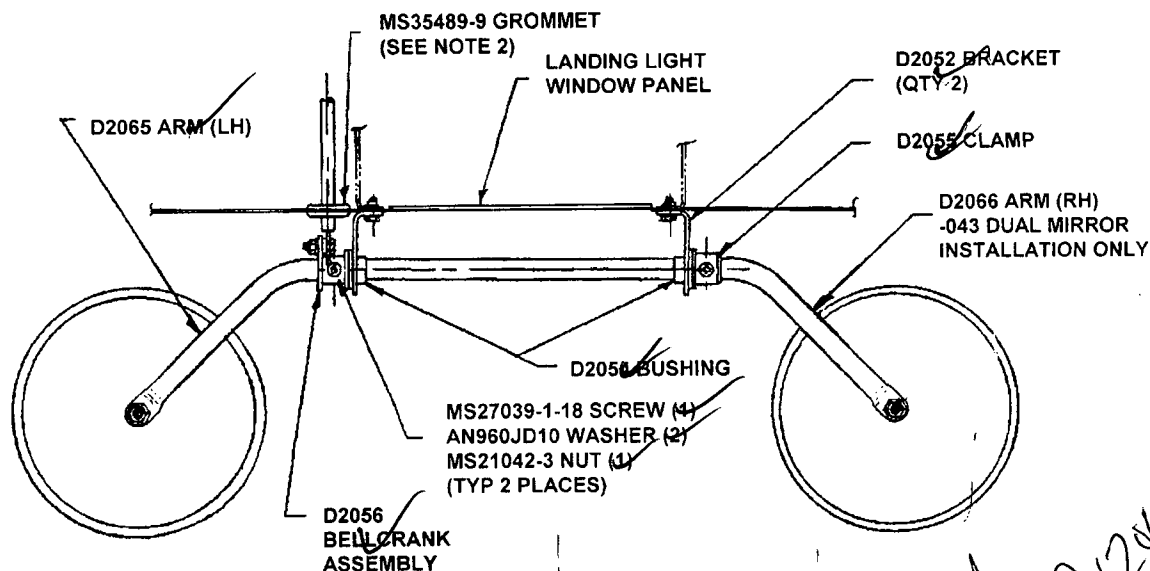


Figure 25.2 - View A: Looking Aft.
(D206-558-043 Mirror Shown)

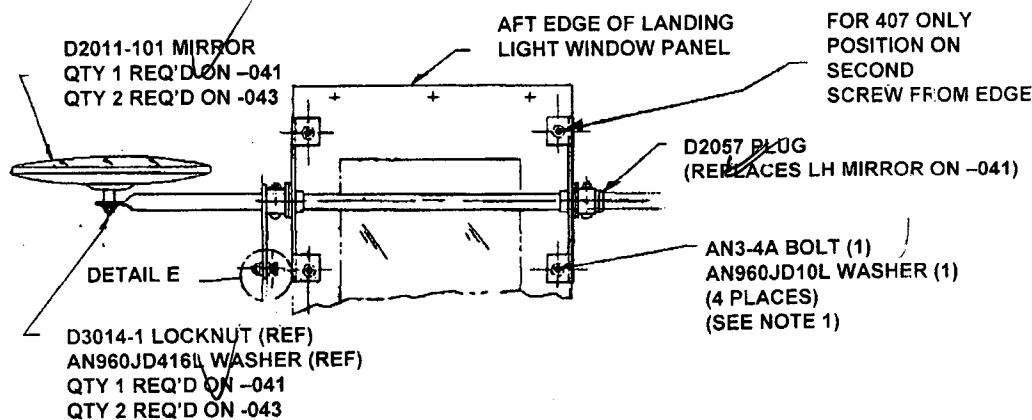


Figure 25.3 - View C: Looking Down on Mirror Installation
(D206-558-041 Mirror Shown)

• COPYRIGHT © 2001 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

FROM THIS POINT FORWARD, CUSTOMERS SHOULD ORDER D407-558-045/-047 IN LIEU OF D206-558-041/-043 WHEN PROCURING SINGLE/DUAL MIRRORS FOR BHT 407 MODELS. AMEND SECTIONS 4.0 AND 5.0 OF INSTALLATION INSTRUCTIONS D206-558 REV. C OR EARLIER AND 25.3 AND 25.4 OF ICA-D206-558 REV. 0 AS FOLLOWS:

4.0 WEIGHT AND BALANCE (D206-558 REV. C OR EARLIER)

25.3 WEIGHT AND BALANCE (ICA-D206-558 REV. 0)

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-558-041	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 206A/B/L/L1/L3/L4	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D206-558-043	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 206A/B/L/L1/L3/L4	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg
D407-558-045	2.4 lb	+5.0 in	+12.0 in-lb	+14.8 in	+35.5 in-lb
Bell 407	1.09 Kg	+0.13 m	+0.14 m-Kg	+0.38 m	+0.41 m-Kg
D407-558-047	3.0 lb	0.0 in	0.0 in-lb	+14.8 in	+44.4 in-lb
Bell 407	1.36 Kg	0.0 m	0.0 m-Kg	+0.38 m	+0.52 m-Kg

5.0 PARTS LIST (D206-558 REV. C OR EARLIER)

25.4 PARTS LIST (ICA-D206-558 REV. 0)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D206-558-041	SINGLE CARGO MIRROR ASSEMBLY
	X			D206-558-043	DUAL CARGO MIRROR ASSEMBLY
		X		D407-558-045	SINGLE CARGO MIRROR ASSEMBLY
			X	D407-558-047	DUAL CARGO MIRROR ASSEMBLY
1	2	1	2	D2011-101	MIRROR ASSEMBLY
2	2	2	2	D2052	BRACKET
1	1	1	1	D2053	BRACKET
2	2	2	2	D2054	BUSHING
1	1	1	1	D2055	CLAMP
1	1	1	1	D2056	BELLCRANK ASSEMBLY
1	1	1	1	D2057	PLUG
1		1		D2065	ARM
	1		1	D2066	ARM
1	1	1	1	D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	1	D2071-3	CABLE ASSEMBLY
1	2	1	2	D3014-1	* LOCKNUT
1	1	1	1	D3778-1	BRACKET
4	4	4	4	AN3-4A	BOLT
4	4	4	4	AN526-1032R9	SCREW
1	2	1	2	AN960JD4T6L	*WASHER
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD10L	WASHER
3	3	3	3	MS21042-3	NUT (or MS21042L3) -2
2	2	2	2	MS21919DG5	CLAMP
2	2	2	2	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
		1	1	MS35489-67	GROMMET





* INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 08.12.04
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9436	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CABLE CHANGE	NTS
DATE	08.12.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			